

Work Order ID 46410-4

June 26, 2009 11:50:58 AM

SPLIT

Item ID: D6101-003

Accept

Setup Start

Revision ID: A

Stop

Item Name: Saddle Billet, 7075

Start Date: 15/07/2009 Start Qty: 300.00

Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 300.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D6101

Rev A

0.00

100



Purchasing

PURCHASING

0.00

Purchasing

Memo

Issue P/O: 8393 a) Description: Alluminum billet : (b) 7.875" x 6.250" x 2.00" thick c) Tolerance on all dimensions are +0.030"/-0.000" d) Grain direction along 7.875" length e) Material: 7075-T7351 (QQ-A-250/12) f) Material certification requi

CX 09/10/23

110



Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

Ensure material certification is attached

0.00

09/11/11 (10)

120



QC

QC6- Inspect dimensions to drawing

0.00

Quality Control

Memo

Ensure Material certification comply to Dwg D6101

0.00

09/11/12

10

# Work Order ID 46410

June 26, 2009 11:50:58 AM



Page 2

Item ID: D6101-003

Accept



Setup Start



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QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: NAT

0.00

*mf 09/11/12*

*10*



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/11/13* *[Signature]*

*mf 09-11-12*

# Picklist Print

June 26, 2009 11:30:05 AM

Work Order ID: 46410

Parent Item: D6101-003RevA

Parent Item Name: Saddle Billet, 7075

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch
D6101-003PRevA		Purchased

7075-17351 2X6.25X7.875



Start Date: 15/07/2009  
Start Qty: 300.00

Required Date: 03/08/2009  
Required Qty: 300.00

Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
No			110	Each	0.0000	300.0000		Pe 9/11/11	



**Castle Metals®**

A. M. Castle &amp; Co.

**PACKING SLIP**

Page 1 of 1

Pack Slip No:6025354

<b>Ship From:</b> Castle Metals MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		<b>Sold To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		<b>Ship To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7		<b>Deliver To:</b> DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
<b>Date Shipped</b> 10-NOV-09	<b>F.O.B.</b> ORIGIN	<b>Freight Terms</b> Prepaid		<b>Carrier</b> MANITOULIN	<b>BOL No</b> 120110-2	<b>Delivery No</b> 6025354	

<b>Shipment Details</b>	<b>Final Destination Branch - MON</b>
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<b>Order No</b> 369825	<b>Line No</b> 2	<b>Item No</b> 6857.MO	<b>Description</b> 2.0000.PL.7075.T7351.ALUMINUM.48.5000.144.5000 CUT 2SIDED TO 6.25 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 7.875")) X 7.875 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 7.875")) - ALUMINUM PLATE SAW			
<b>Purchase Order No</b> 8393		<b>Part Number</b>		<b>Ordered Qty</b> 10 PCS	<b>Invoice Qty</b> 10 PCS	<b>Backorder Qty</b>
<b>Details</b>						
<b>Mill</b>	<b>Heat Number</b> 456750A9	<b>Mech Id</b>	<b>PCS</b> 10	<b>Width (IN)</b>	<b>Length (IN)</b>	<b>Shipped Qty (LBS)</b> 99.48

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.	
We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.	
This material has been received and inspected by:	Date:

*aml 09/11/12*

<b>SHIP TO:</b> A M CASTLE & CO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131
<b>SOLD TO:</b> AM CASTLE & CO- SOLD TO 3400 NO. WOLF ROAD FRANKLIN PARK, IL 60131

# KAISER

## ALUMINUM

Trentwood Works - Spokane, WA 99215  
 Phone: (800) 367-2586

### CERTIFIED TEST REPORT

Serial Number  
 4149447

CUSTOMER PO NUMBER: 01-15905		WORK PACKAGE:		CUSTOMER PART NUMBER: 6857 A97075-60		SHIP RUN/LOAD ID: 101432/16		GOVT CONTRACT NUMBER:	
KAISER ORDER NO: 1075544	LINE ITEM: 1	SHIP DATE: 11-DEC-2008	ALLOY: 7075	CLAD: BARE	TEMPER: T7351	PRODUCT DESCRIPTION: MILL FINISH PLATE			
WEIGHT SHIPPED: 5732 LB	QUANTITY: 4 PCS EST.	B/L NUMBER: 2020688	GAUGE: 2.0000 IN		WIDTH: 48.500 IN	LENGTH: 144.500 IN			

### Certified Specifications

AMS 4078/RevG  
 ASTM B 209/Rev07  
 BSS 7055/RevA  
 DPS 4.713/RevAH  
 G8816100/RevG/Amd1

AMS-QQ-A-250/12  
 ASTM B 594/Rev06  
 CMMP 025/RevR  
 EAC MS1011/RevE  
 MMS 159/RevN

AMS-STD-2154  
 BAC 5439/RevH  
 CSTI 008/RevC  
 GAMP8 9101/RevB  
 PS 21211/RevK

Test Code: 4297

### Test Results

Lot: 456514A9 Cast 198

Drop 21

Ingot 1

(ASTM E8/B557)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	73.2 : 73.8 (508 : 509)	63.6 : 84.9 (439 : 447)	11.6 : 11.8

(ASTM E1004)

Conductivity %IACS :	41.2 Min	41.7 Max
(MS/M) :	23.9 Min	24.2 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.08	0.21	1.5	0.03	2.4	0.19	5.7	0.03	0.01	0.01	TOT 0.05

*cmf* 09/11/12

**KAISER  
ALUMINUM**Trentwood Works - Spokane, WA 99215  
Phone: (800) 367-2586**CERTIFIED TEST REPORT**Serial Number  
4149447

Lot: 456750A9 Cast 193

Drop 20

Ingot 1

(ASTM E8/B667)

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T7351	LT / 2 (Min:Max)	73.1 : 73.7 (504 : 508)	62.7 : 83.4 (432 : 437)	11.9 : 12.1

(ASTM E1004)

Conductivity %IACS :	41.8 Min	42.2 Max
(MS/M) :	24.2 Min	24.5 Max

(ASTM E1251)

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.08	0.22	1.4	0.02	2.4	0.20	5.7	0.03	0.01	0.01	TOT 0.05

**ALLOY LIMITS**

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
7075 MIN	0.00	0.00	1.2	0.00	2.1	0.18	5.1	0.00	0.00	0.00	EACH	0.05
MAX	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.05	TOT	0.15

Aluminum Remainder

**TEST NOTES**

7075-T7351 plate 3.001-3.500" thick, if ultrasonically inspected, meets requirements of CMMPO25 per SDR  
CMMPO25-KaiserT-1. 7075-T7351 plate 3.501-5.000" thick, if ultrasonically inspected, meets requirements of CMMPO25 per SDR CMMPO25-KaiserT-2.

Metal represented by this test report was immersion ultrasonically tested from one side and meets the Class A and Class B requirements of all specifications referenced on this test report.

CASTLE METALS CORP.  
DATE RCVD 12/16/08  
IAC 6851008  
APPROVED BY [Signature]

**CERTIFICATION**

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE UNITED STATES OF AMERICA OR A QUALIFYING COUNTRY PER DFARS 225.172-1(b), WAS MANUFACTURED IN THE UNITED STATES OF AMERICA, AND MEETS THE REQUIREMENTS OF DFARS 253.223 FOR DOMESTIC CONTENT. THIS MATERIAL HAS BEEN INSPECTED, TESTED, AND FOUND IN COMPLIANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. 180-9001:2000 CERTIFIED.

BILL POYNOR, LABORATORIES SUPERVISOR

[Signature]